

Date: Wednesday, 01/10/2008 11:24:25 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2893-1
Job Number : 42374	
Estimate Number : 13234	
P.O. Number :	Part Number : DSK078
This Issue : 01/10/2008 S.O. No. :	Drawing Number : DSK078 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 42259	Material :
Written By :	Due Date : 15/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLO 08.10.01</u>	
Comment : est rev A. 08.03.13 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6104005	Round Billet, 17-4
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B 41966



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Support

J-F. 08/10/05

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: ~~MORI SEIKI CNC LATHE LARGE~~
Turn blank as per Folio FA081

Doosan

J-F. 08/10/05

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-F. 08/10/05

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SS 08/10/05

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock in Kanban
Location: DSK078 CNC

SS 08/10/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 01/10/2008 11:24:25 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TURNING DETAIL FOR D2893-1

Job Number: 42374

Part Number: DSK078

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/08 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42374
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.707"	2.709"	2.709"	2.709"	2.710"
B	4.946	4.966		4.949"	4.955"	4.961"	4.962"	4.958"
C	3.064	3.084		3.074"	3.074"	3.074"	3.075"	3.075"
D	0.718	0.738		.728"	.728"	.728"	.728"	.728"
E	0.090	0.110		.100"	.100"	.100"	.100"	.100"
F	2.934	2.954		2.944"	2.943"	2.944"	2.944"	2.944"
G	2.166	2.186		2.176"	2.176"	2.176"	2.176"	2.176"
H	3.890	3.910		3.899"	3.898"	3.900"	3.899"	3.901"
I	0.914	0.934		.923"	.923"	.923"	.923"	.923"
J	0.022	0.042		.032"	.032"	.032"	.032"	.032"
K	0.109	0.129		.118"	.119"	.119"	.119"	.119"
L								
M								
N								
O								
P								

Measured by: J.F.	Date: 08/10/05
Audited by: SF	Date: 08/10/05
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action — Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42374
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

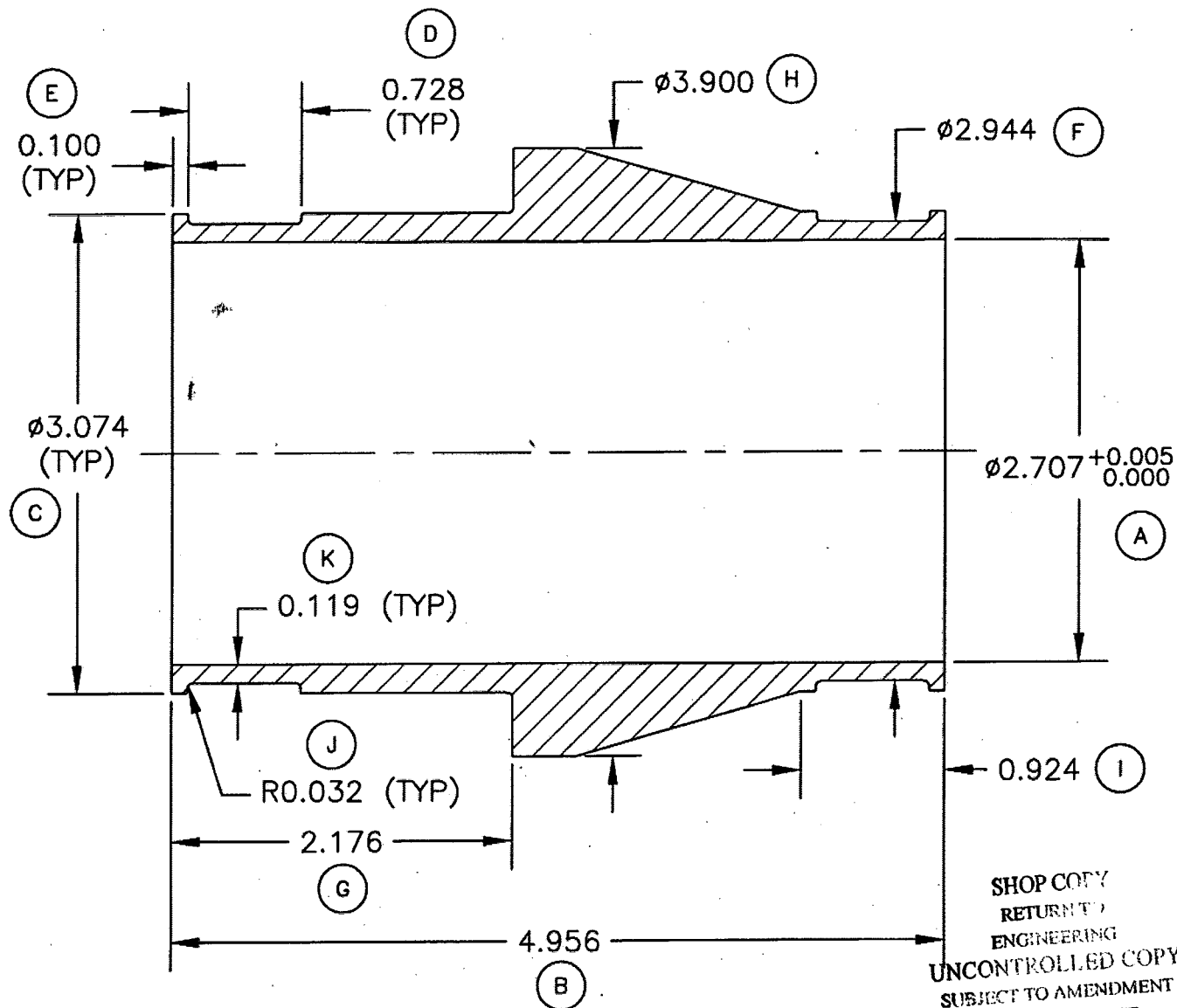
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	#9	#10
Lathe Section								
A	2.707	2.712		2.709	2.709	2.709	2.709	2.709
B	4.946	4.966		4.958	4.958	4.958	4.959	4.954
C	3.064	3.084		3.075	3.075	3.075	3.075	3.074
D	0.718	0.738		.728	.728	.727	.723	.728
E	0.090	0.110		.100	.100	.100	.101	.099
F	2.934	2.954		2.944	2.944	2.945	2.946	2.944
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.898	3.899	3.899	3.899	3.898
I	0.914	0.934		.923	.923	.923	.923	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.119	.119	.119	.119	.119
L								
M								
N								
O								
P								

Measured by: J.F.	Date: 08/10/05
Audited by: [Signature]	Date: 08/10/05
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	[Signature]

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42374

D2893-1 TURNING DETAIL